Work Order ovember-06-12 1			*926	344*						Page 1
tem ID: D. Revision ID: tem Name: Re	350-567-113 eplacement Window, Extra Lar 1/06/12 Start Qty: 3.	.00 1 *3*	Accept	*N900 Cust Item Customer:	ID:	100		Setup Sta Sto	P *N	S1* S2*
*	Process Plan: MLJ				oate:]	Run Sta Sto		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
IIN-D350-567	Rev D	1 B							MUS	17-12-19
*100 *100* DC Document Control	DOCUMENT CO Mem Photo		0.00 12 1	ЛS СНG003						12/18/
*110 *110* Packaging Packaging	Packaging Mem Pick ***E	no Packing Kit ENSURE DT 8439 TEMPLATI	0.00 0.00 E IS INCLUDED***					·		12/12/19/
¹²⁰ *12∩*	QC4- 100% Inspe	ect kits for completeness	0.00 Smf							
[®] QC	Men	no	0.00	19						•

Quality Control

			DQA:	Date:	4
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	-		

									QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DEI	PARTMENT	PROCESS	: .
Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
WON I			· · · · · · · · · · · · · · · · · · ·			J .	20.80 100	55pose			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				-							
Operator										ut v	
Material											
Setup	_										
Other											
Process											
Supplier					•						
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Unapproved	<u> </u>	1	1			AULT CATE	GORY				<u> </u>
Landir	ng Gear				General	.JEI CAIL					
31 (5 8	Bending			Γ	Bend	Grain			Ovalized	Г	Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	\vdash	ion Incomplete		Part Incorre	<u></u> ⊢	Weld
	Crushed/	Crimped.			Burrs	\vdash	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ľ	Cuffs	•			Contamination	Mainte			Part Moved		_
	Heat Trea	at			Countersink	Mislabe			Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	_	Other
	Ripples in Bend Drill Holes			Drill Holes	Offset			•			
	Torque W	/aves in E	xtrusio	,	Drawing	Out of Calibration					
Ī	Turning Sequence Finish			Out of Sequence							
	Wave/Tw	Vave/Twist in Tube Folio			Folio	Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2 November-06-12 12:26:43 PM D350-567-113 Accept *N900040100* Setup Start Item ID: **Revision ID:** Replacement Window, Extra Large Item Name: 11/06/12 **Start Oty: 3.00** Start Date: **Cust Item ID:** Required Date: 11/16/12 Rea'd Oty: 3.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Operation Set Up/ Accept Number Stamp Description **Run Hours** Code Otv Otv Work Center ID 0.00 130 Packaging My (3-15, +a) *120* 0.00 Packaging Memo Identify and pack for shipping as per PPPD350-567-113 Packaging Location: PPP Rev: 0.00 140 OC21- Final Inspection - Work Order Release ML5 12-12-19 MF *140* 0.00 OC Memo Quality Control

DQA:	Date:	4	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:
Work Orde	r·				DISPOSITION		٠.	AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	·	rie.			Rework	7	Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap	┪ [Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		,			Use-as-is	The	moforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	0.				Work Order Update]	Large Fab	Composite		Supplier	
			· · ·	,							
Root					ption of work order update	Initial	1	ction	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data	_										
quip/Tooling	_	[
Operator	_										
Material											
Setup	_										
Other	_			*, ÷							
rocess											
Supplier							·				
Training		1									
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						AULT CAT	EGORY				
Landin	g Gear			_	General				٦	_	_
	Bending			ļ	Bend	Grain		<u> </u>	Ovalized	1	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardv		<u> </u>	Over/Under	 	Temperature/Cure
	Cracks				Broken/Damaged		tion Incomplete	<u> </u>	Part Incorre	⊢	Weld
	Crushed/	Crimped.			Burrs	_	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			_	Contamination		tenance		Part Moved		
	Heat Trea	it			Countersink	Misla			Positioned V		
	Inspection	n Strip in	Tube		Cut Too Short	Misre			Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Offset					
Torque Waves in Extrusion Drawing			Out of Calibration								
	Turning S	equence			Finish	Out o	f Sequence				
Wave/Twist in Tube Folio			Folio	Outsi	Outside Dimensions						

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Work Order ID:

92644

Parent Item:

D350-567-113

Parent Item Name:

Replacement Window, Extra Large

Comments:

IPP Rev:A 04-08-24 New Issue JLM

Page 1

Start Date: 11/06/12

Required Date: 11/16/12

Start Qty: 3.00

Required Qty: 3.00

<u> </u>	IPP Rev:B 08-10-	-07 as per revid	UD VCIII	ica by.									<u> </u>
Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
12-12 eceptacles		Purchased	No			110	Each	217.0000	12	36	- 31	3	ST)
The second secon				Location		Loc Qty	<u>L</u>	oc Code					
5m(-)				380		169							
-71.8					22452	169			17:	2452			
				ST365		48							
					20077	20							\wedge
4.	*			12	21827	28			,				
600-6		Purchased	No			110	Each	639.0000	12	36	2	3_	
ämlock Stud				Location		Loc Qty	<u>L</u>	oc Code					
·				396		17							
- 3/"				1:	22763	17							
				ST365		622							
· ·				1:	20077	4							
					21287	32							
					22441	86			10	1972			A Property of the Contract of
#* #*					22973	200			<u>تر (</u>	2973		1	
<u> </u>				ì	23150	300	.					•	
amloc Retaining Washe	r	Purchased	No			110	Each	695.0000		36	25		12/12/
^				Location		Loc Qty	<u>L</u>	oc Code			•		
				ST365		695							
					21524	9							
					22317	80							
					22452	127			10	2913			
					22973	179			10	<u> </u>			
				1	23150	300			·~-				

			DQA
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

IVCIV.	C3 / NO				WORK ORDER NOW				QA Closed:	Date:	7.6
Work Orde	ır.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap]	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
raitiv					Use-as-is	- 1	noforming	Finishing	1	e/Packaging	Other
NCR N	lo		·····		Work Order Update] ''''	~ 	Composite	, recystor	Supplier	
Root				Descri	ption of work order update	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	4	or Non-conformance	Chief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data									į į		:
Equip/Tooling		1									
Operator							•				
Material	_	Ī									
Setup											
Other											
Process										·	;
Supplier	_										
Training											
Unapproved		<u> </u>									
					F	AULT CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landir	ng Gear				General			_		_	
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete	<u> </u>	Part Incorre	ct	Weld
	Crushed/	Crimped.		_	Burrs	Instruct	tions Incomplete/Ur	nclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	it			Countersink	Mislabe	eled		Positioned \	Vrong	_
Į	Inspection	n Strip in	Tube		Cut Too Short	Misread	d ·		Power Loss/	Surge	Other
Į	Ripples in	Bend			Drill Holes	Offset					
	Torque W	aves in E	extrusion	ո [Drawing	Out of	Calibration				
Turning Sequence Finish			Out of :	Out of Sequence							
Wave/Twist in Tube Folio				Outside	Outside Dimensions						

Date:

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FG-778150-550-ROL

Purchased

No

123239

Location

ST416

Loc Qty 1747.5 1747.5

110

Loc Code

1,747.5000

23239

November-06-12 12:26:43 PM

Shop Packet Print

Page 2

DQA:	Date:	3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	,								QA Closed:	Date	:
Work Orde	ır.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	- I	Skid-tube Machining moforming	Crosstube Small Fab Finishing	4 .	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo		,		Work Order Update]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier											
Training	_					-					
Unapproved		<u> </u>	l	<u> </u>		AULT CATE	CORV		<u> </u>	1	
:1						AULI CATE	GUKY				
Landir	ng Gear				General	Crain		Γ-	Ouglined	۲	Drossuro/Forcod
```	Bending Centre-N Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged	Grain Hardw	are tion Incomplete	-	Ovalized Over/Under Part Incorre	<del> </del>	Pressure/Forced Temperature/Cure Weld
,	Crushed/	Crimped.	-		Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		enance		Part Moved		
ļ	Heat Trea				Countersink	Mislab		_	Positioned V	· · ·	_
ļ	Inspectio		Tube	L	Cut Too Short	Misrea	d	<u></u>	Power Loss/	Surge	Other
ļ	Ripples ir			<u> </u>	Drill Holes	Offset				<del></del>	
	Torque W			n	Drawing	$\vdash$	Calibration				
	Turning S				Finish		Sequence				
Wave/Twist in Tube			Folio	Outsid	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-06-12 12:26:43 PM

Work Order ID:

92644

Parent Item:

D350-567-113

Parent Item Name:

Replacement Window, Extra Large

MS20426AD3-5

MIS21042L08

Rivet

Nut

Purchased

No

No

110 Each

11,508.000

**Start Date:** 11/06/12

4444

**Required Date:** 11/16/12

Start Qty: 3.00

Required Qty: 3.0

Purchased

Location Loc Qty ST316 11508 4179 390 4444 5022 6096 4533

110

Loc Qty Location 315 122452 9 500 ST315 122814 500 ST317 479 122141 479 Loc Code

Each

Loc Code

22141

									DQA:	Date:	7
NCR: Yes	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	11 / 1 1 1.
Work Order.					Rework		Skid-tube	Crosstube	1	Water Jet	Engineering
Part No.					Scrap	ł <b>I</b>	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1 1	noforming	Finishing	4	re/Packaging	Other
NCR No.	<u>-</u>				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		. *
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									·		:
Equip/Tooling		1									
Operator [											
Material											
Setup										ļ	,
Other											
Process	]					1			1		

**Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Cracks Part Incorrect Weld Instructions Incomplete/Unclear Crushed/Crimped. Burrs Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Supplier Training Unapproved

## **PARTS LIST** 5.0

-015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
<del></del>	х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
<del>                                     </del>				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
<del></del>	<del>- '-</del>	1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
<b></b> -		<del>                                     </del>	<u> </u>	1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1	<b></b>	1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty	Qty	,@ty-	Qty	Qty		
-013	-023	113	-115	-031	Part Number	Description
$\frac{310}{x}$					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
<del></del>	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				Х	D350-567-031	INTERIOR FLOOR WINDOW KIT
1						(SLIDING DOOR COMPATABLE)
						DEDI A CEMENT WINDOW ONALL
1	,				D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		Ç1			=D3290=041=====	REPLACEMENT WINDOW ASSEMBLY-EXTRA LARGE
<del>- 1</del>					D2126-0600	SEAL
<del>                                     </del>	1		·		D2463-0750	NEOPRENE SEAL
1		[1			D2463-0860	NEOPRENE SEAL 7
	9	<i>6</i> 12==			-2600-6	-1/4-TURN-FASTENER
-	9	£125.		The said		WASHER-
	9	12	= 3		212-12	
	22	[21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	L 42			AN960JD8	WASHER
	22	<b>(</b> 21	0.000 March 100		MS21042L08	_NUT. (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	£2-SQ.			N/A	T9:70z-7781-S'-GLASS-UNIVERSAL WEAVE
YD	YD	YD				And the second s
					D0400 0450	NEOPRENE SEAL
		<u> </u>		1	D2463-0450	DOUBLER
				1	D3210-1	BRACKET
				1	D3211-1	
				1	D3212-1	FLOOR WINDOW DOOR ASSEMBLY
			4	11	D3213-041	DOUBLER
			1		D3293-1	
		-	1		D3294-1	BRACKET FLOOR WINDOW
			1	<del> </del>	D3295-041	DOOR ASSEMBLY
		ļ	1	ļ	D3296-041	NEOPRENE SEAL
			1	<del>  </del>	D2463-0530	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN526C632R12	WASHER
		-	9	8	AN960JD6	
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
		L	15	20	MS20470AD4-7	RIVET

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Revision: **D** 

Date: 08.07.08